

Date: Thursday, 1/17/2008 3:23:50 PM  
Ref: Kim Johnston

## Process Sheet

SP215

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SUPPORT	
Job Number	: 36811A		Part Number	: D32781	
Estimate Number	: 10452		Drawing Number	: D3278 REV. C	
P.O. Number	:		Project Number	: N/A	
This Issue	: 1/17/2008 S.O. No. :		Drawing Revision	: C	
Prsht Rev.	: NC		Material	:	
First Issue	: / / Type : SMALL /MED FAB		Due Date	: 1/24/2008 Qty: A2	
Previous Run	: 36119A		Um:	Each	
Written By	:			1/17/2008	
Checked & Approved By	:			1/17/2008	
Comment	: Est:A 04.04.19 New issue KJ/JLM est B 07.09.06 rev.c dwg EC verified by: JLM			1/17/2008	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B1000X02000	6061-T6 Bar 1.0" x 2.0"
		Comment: Qty.: 0.2454 f(s)/Unit Total: 10.3062 f(s) 45.1536 ft Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick 55.9512 ft (M6061T6B1.000x02.000) Batch: M106563 x 21.5 FT m105817 x 30 FT
2.0	SHEAR	SHEAR
		Comment: SHEAR Cut blank: 2.00" x 1.00" x 2.550" long
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		Comment: HAAS CNC VERTICAL MACHINING #1 1- Machine as per Folio FA405 and Dwg D3278 2- Deburr and Tumble Identify as D3278-1
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
5.0	QC8	SECOND CHECK
		Comment: SECOND CHECK
1.1 ISSUE P#:		5655
GLOBUS.		1/17/2008 18:22:28
1.2 RECEIVING AND ATTACHING CERT		1/17/2008 18:27:18
1.3		1/17/2008 18:42:42



DART AEROSPACE LTD	Work Order:	36811A
Description: Support	Part Number:	D3278-1
Inspection Dwg: D3278 Rev: C		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article     Prototype

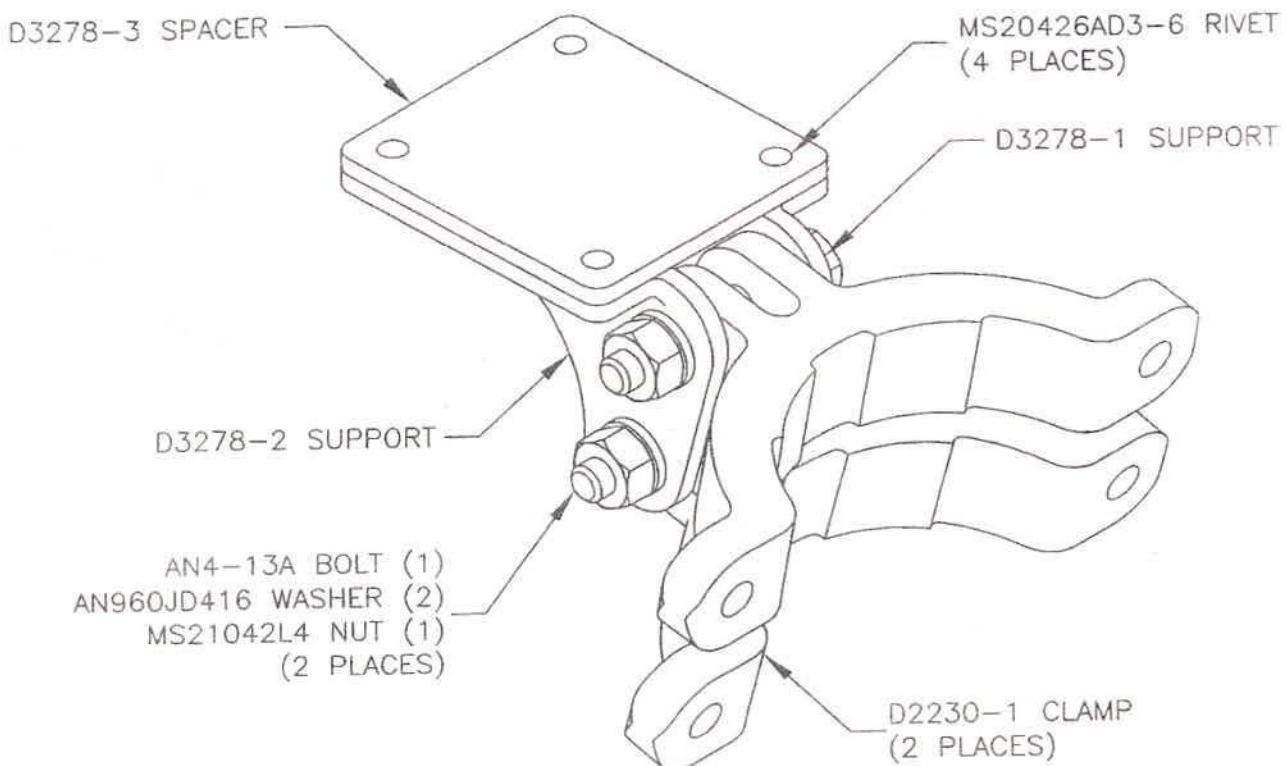
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000					
0.359	+/-0.005					
0.609	+/-0.010					
0.250	+/-0.010					
1.480	+/-0.005					
R0.125	+/-0.010					
0.119	+0.005/-0.004					
2.439	+/-0.010					
1.980	+/-0.010					
R0.13	+/-0.030					
Ø0.257	+0.005/-0.000					
R0.375	+/-0.010					
0.875	+/-0.010					
0.500	+/-0.010					
R0.400	+/-0.010					
R1.00	+/-0.030					
1.720	+/-0.010					
R0.125	+/-0.010					
0.125	+/-0.010					

Measured by:		Audited by:		Prototype Approval:	N/A
Date:		Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	
C	07.09.26	Dimensions updated per Dwg Rev. C	KJ/EC	E

**DART**

DESIGN <i>QP</i>	DRAWN BY <i>JL</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>HH</i>	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

**RELEASED**  
*07.08.08*D3278-041 SUPPORT ASSEMBLY

Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

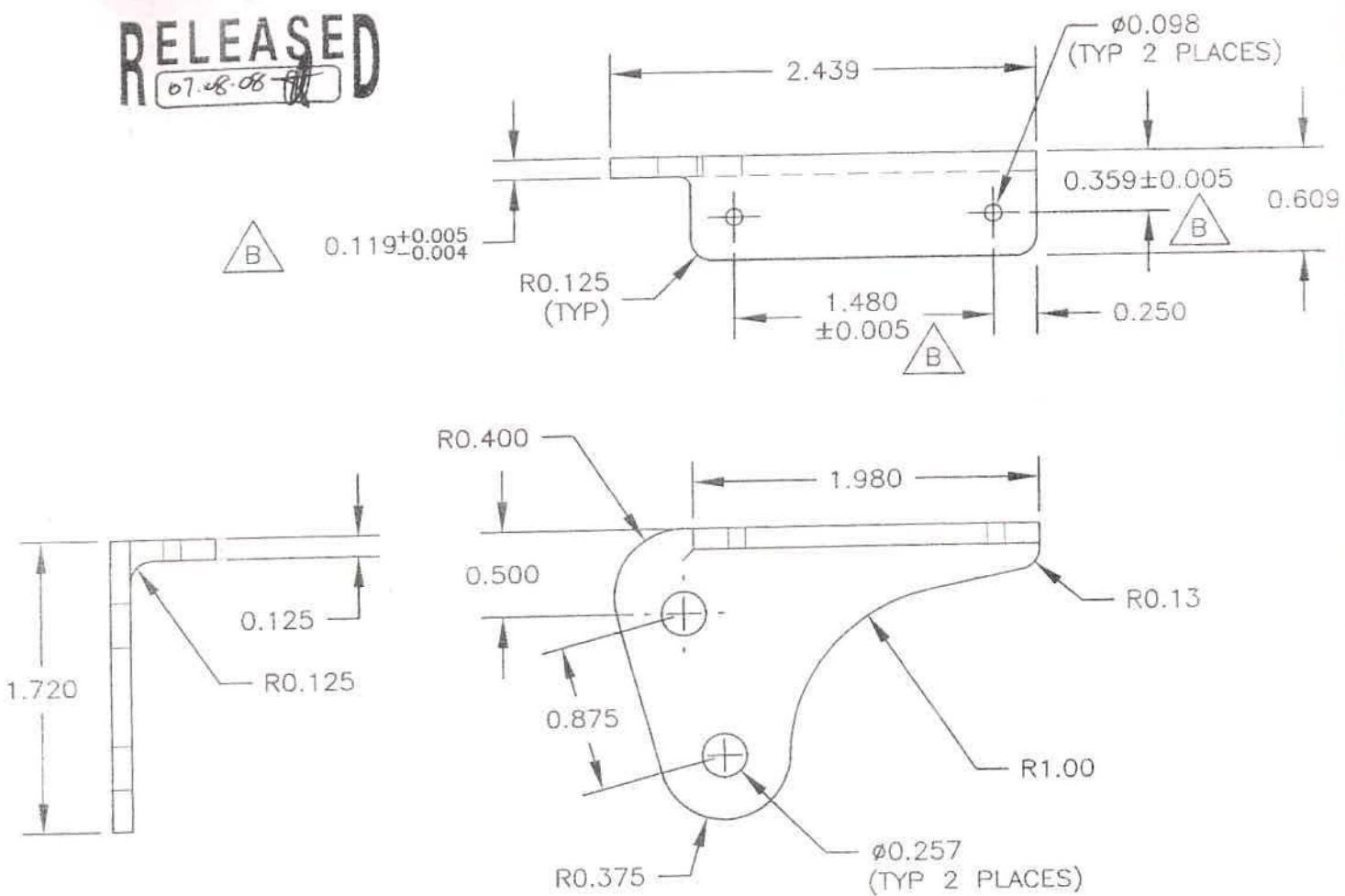
SHOP C P1  
RE 1  
C 1  
U 1  
UN 1  
SUB 1  
W 1  
W 1  
W 1  
NO 36811A

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED  
OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

**DART**

DESIGN <i>QP</i>	DRAWN BY <i>DC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278
DATE 07.07.24		REV. C SHEET 2 OF 3 TITLE SCALE 1:1 SUPPORT ASSEMBLY

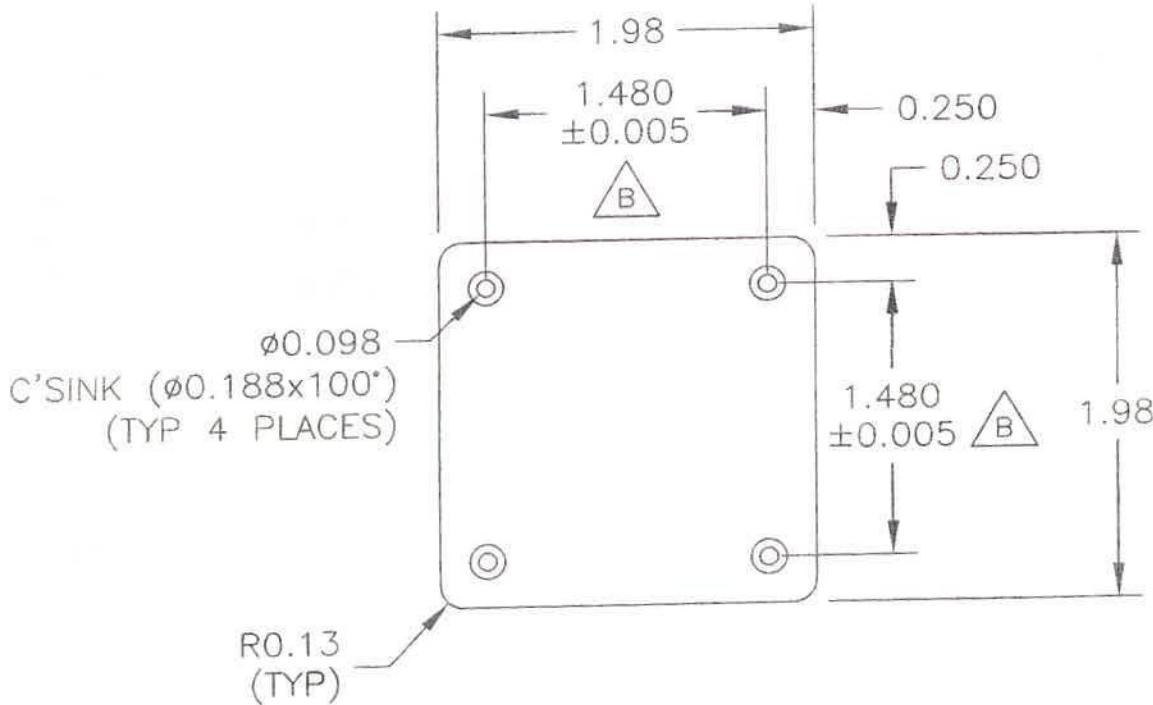
**RELEASED**  
07.08.08**D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

NO 3681A

**DART**

DESIGN <i>GP</i>	DRAWN BY <i>SC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

**RELEASED**  
07.08.08**D3278-3 SPACER**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL  
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR  
DELRIN II 150E OR ACETRON GP ACETAL  
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

SHOP DRAWING  
REVISION C  
DRAWN BY  
UNPRINTED  
SUBJECT TO CHANGE  
WILL BE  
NO. 36811A

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

**GLOBUS**  
PRECISION INC.

36 Colonnade Road N.  
Ottawa, Ontario K2E 7J6  
Tel: (613) 226-1579  
Fax: (613) 226-1719

**Invoice**

DATE	INVOICE NO.
3/18/2008	17013

BILL TO
Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7

SHIP TO
Main Finished Goods Location Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7

P.O. NO.	TERMS	SHIP DATE	SHIPPED VIA	JOB NO.	FOB
000005655	Net 30	3/18/2008	Pick-Up	632	Globus
QTY	DESCRIPTION				RATE
187	D3278-1 B36811A Support				7.63

Business Number: 102122058

(b)

GST	71.34
PST	0.00
<b>TOTAL</b>	<b>\$1,498.15</b>

WHITE = Original  
BLUE = C of C  
YELLOW = Packing Slip

Carrying Charge - 2% per Month -24% per Annum  
on Overdue Accounts